

Date: Monday, 17/11/2008 11:52:45 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 43487		Part Number	: D3121144	
Estimate Number	: 10290		Drawing Number	: D3121 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 17/11/2008	S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	: MACHINED PARTS		
Previous Run	: 42191		Due Date	: 24/11/2008	
Written By	:		Qty:	20	Um: Each
Checked & Approved By	: <u>JL 08-11-17</u>				
Comment	: Est Rev:Pick:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC Est Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B1250X02000	17-4 SS Bar 1.250 x 2.00
		 <b>Comment:</b> Qty.: 0.3864 f(s)/Unit Total : 7.7280 f(s) <i>NOT ENOUGH MTL IN COMPUTER</i> Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.250 x02.000) Identify for D3121-114 Batch: <u>M109487</u> <i>mk 08/1/23</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
2.0	BAND SAW	BAND SAW
		 <b>Comment:</b> BAND SAW Cut blanks: (1.250" x 2.000") 4.425" long <i>mk 08/1/23</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 <p>1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114            2-Deburr            3-Scribe batch number <i>J.F./mk 08/1/28</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span></p>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>J.F./mk 08/1/28</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							/

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 11:52:45 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 43487

Part Number: D3121144

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/12/04 (20)

6.0 D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3121-21 Bolt B43536 (16x)

B43536 (16x)

B43536 (16x)

08/12/04

7.0 D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3121-241 Bearing Ass B43537 (7x)

B43537 (7x)

08/12/04

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

08/12/04 (20)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/04 (20)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 233

08/12/04 (20)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/05 (20)

Job Completion



08/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>43481</u>
Description: Bracket		Part Number: D3121-114
Inspection Dwg: D3121	Rev: E	Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	—			
0.300	+/-0.010	.300	—			
R0.375	+/-0.010	R.375	—			
1.54	+/-0.030	1.540	—			
0.350	+/-0.010	.350	—			
R0.25	+/-0.030	R.250	—			
Ø0.392	+0.002/-0.000	Ø.3933	—			
Ø0.201	+0.005/-0.000	Ø.203	—			
0.100	+/-0.010	.099	—			
2.540	+/-0.010	2.540	—			
1.590	+/-0.010	1.590	—			
0.160	+/-0.010	.160	—			
0.400	+/-0.010	.403	—			
1.220	+/-0.010	1.225	—			
1.600	+/-0.010	1.604	—			
3.80	+/-0.030	3.813	—			
1.800	+/-0.010	1.802	—			
R0.50	+/-0.030	R.500	—			
0.130	+/-0.010	.127	—			
3.41	+/-0.030	3.410	—			
3.65	+/-0.030	3.638	—			
2.24	+/-0.030	2.210	—			
45°	+/-0.1°	45°	—			
R0.25	+/-0.030	R.250	—			
3.97	+/-0.030	3.973	—			
R0.38	+/-0.030	R.380	—			
Ø0.392	+0.002/-0.000	Ø.3933	—			
Ø0.201	+0.005/-0.000	Ø.203	—			
0.268	+/-0.010	.268	—			
R0.260	+/-0.010	R.260	—			
0.080	+/-0.010	.080	—			
0.300	+/-0.010	.300	—			
0.381	+/-0.010	.376	—			
0.201	+/-0.010	.200	—			

DART AEROSPACE LTD	Work Order:	43487
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121	Rev: E	Page 2 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

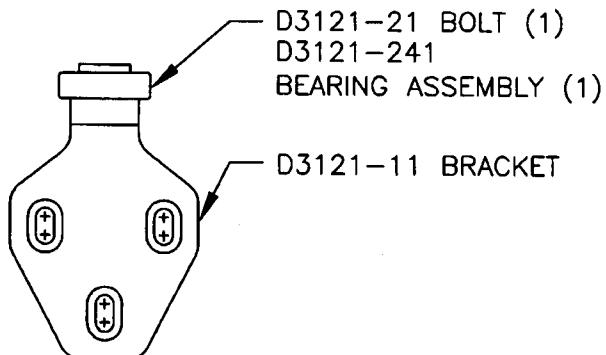
## X First Article      Prototype

Measured by:	<i>John</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	08/11/28	Date:	08/12/04	Date:	N/A

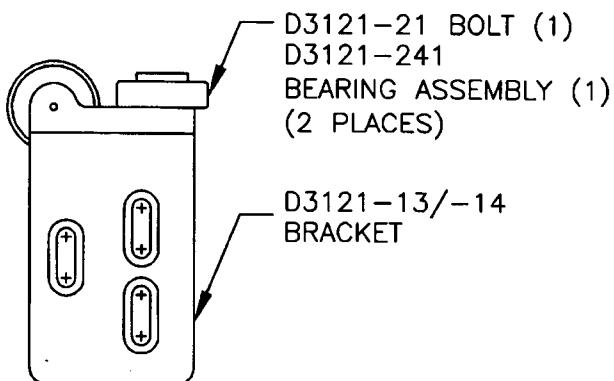
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-144	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev E	KJ/EC/DD,	
E	08.05.20	0.032 dimension was 0.32	KJ/DD	 

**DART**

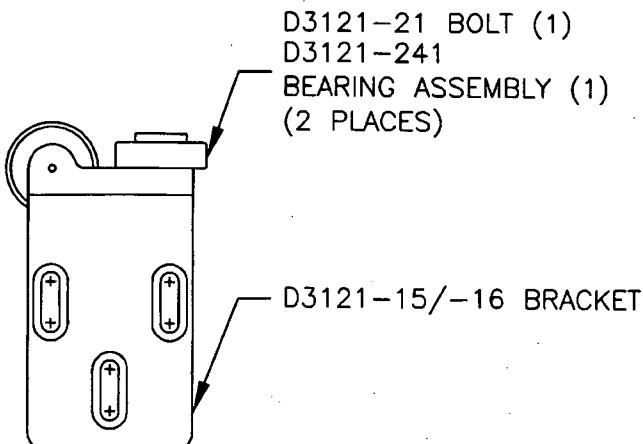
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CHECKED <i>4</i>	APPROVED <i>MM</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

**RELEASED**  
*07.11.07***D3121-041 BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-33)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-37/-38)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-35/-36)

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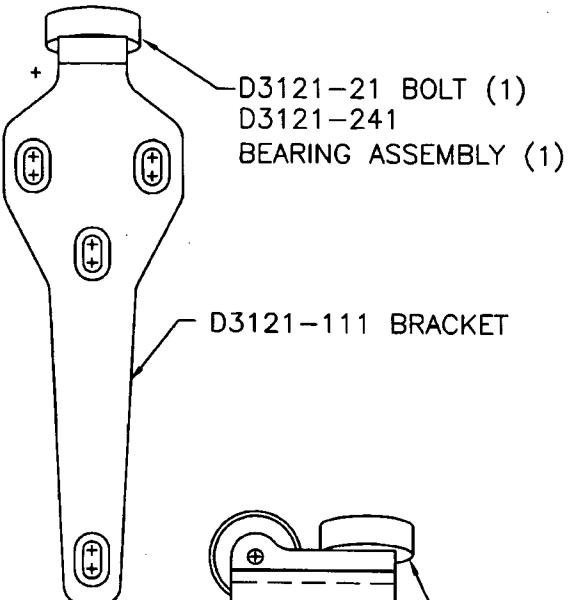
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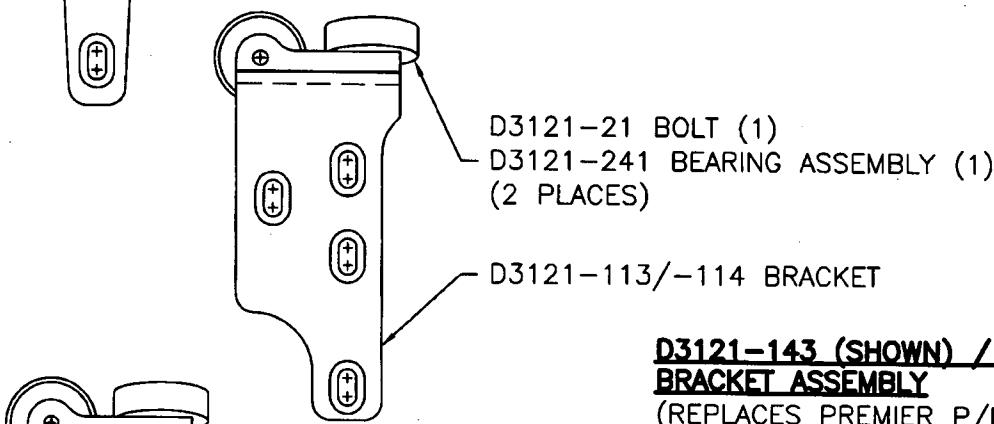
REV. E  
SHEET 2 OF 10  
1:2

07.11.07  
BRACKET ASSEMBLY

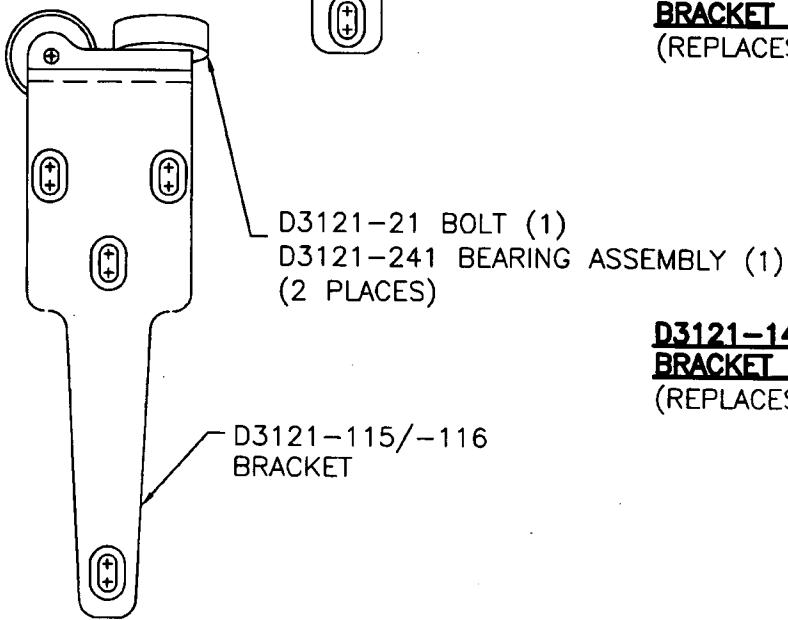


**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

RELEASED  
07.11.07



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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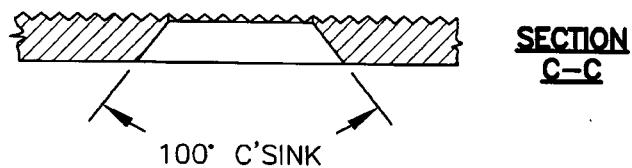
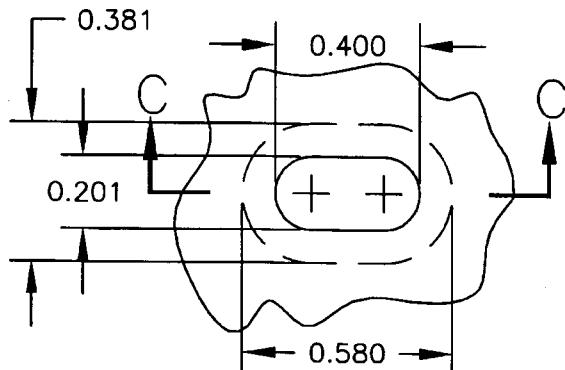
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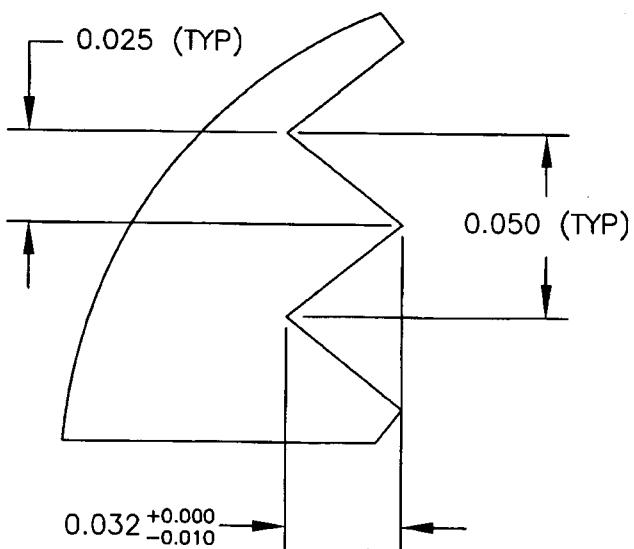
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		D3121	SHEET 3 OF 10
DATE	TITLE	SCALE	
07.11.07	BRACKET ASSEMBLY	1:1	

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**RELEASED**  
07.11.07

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



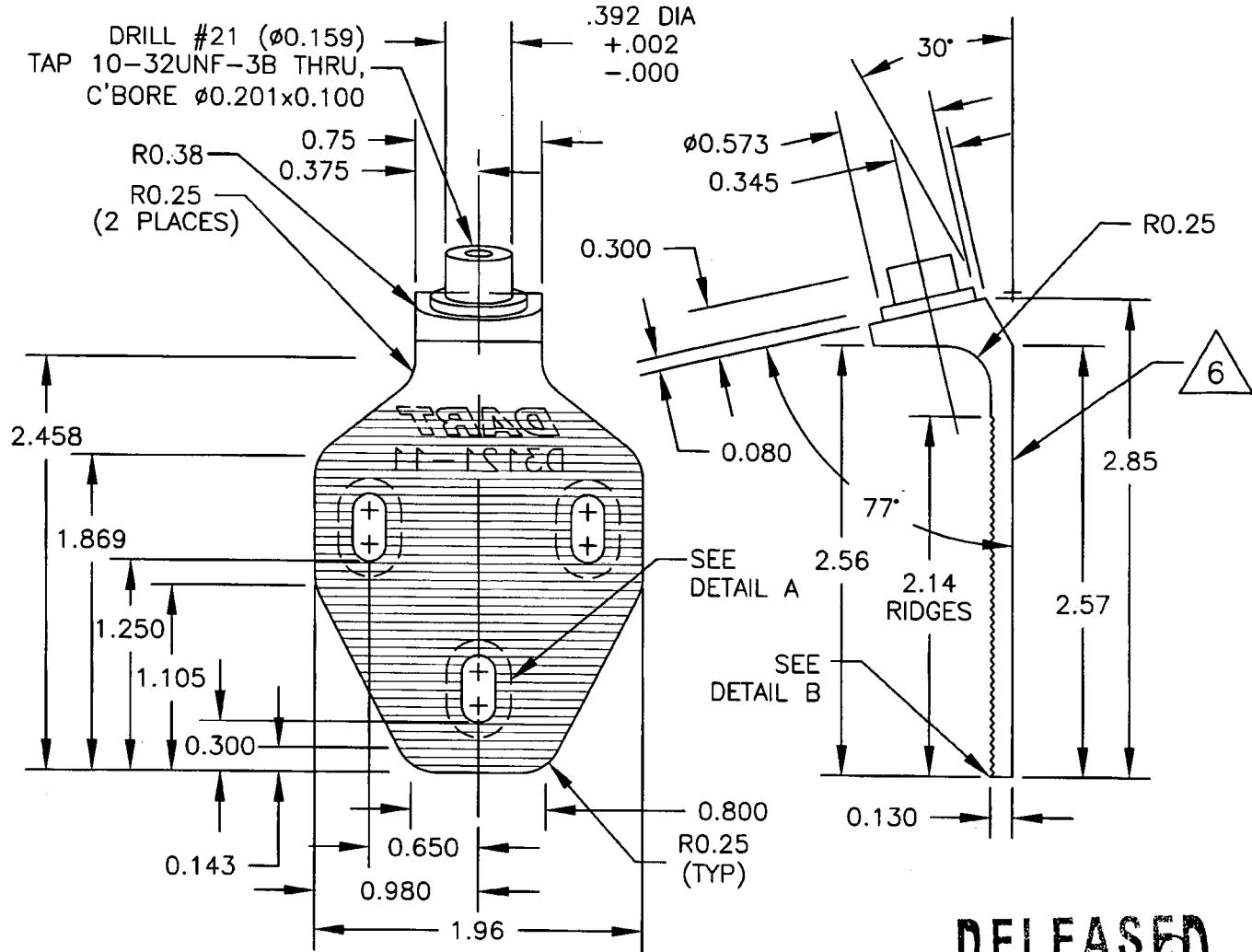
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DATE		DRAWING NO.	SHEET 4 OF 10
07.11.07		TITLE	SCALE
		BRACKET ASSEMBLY	1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

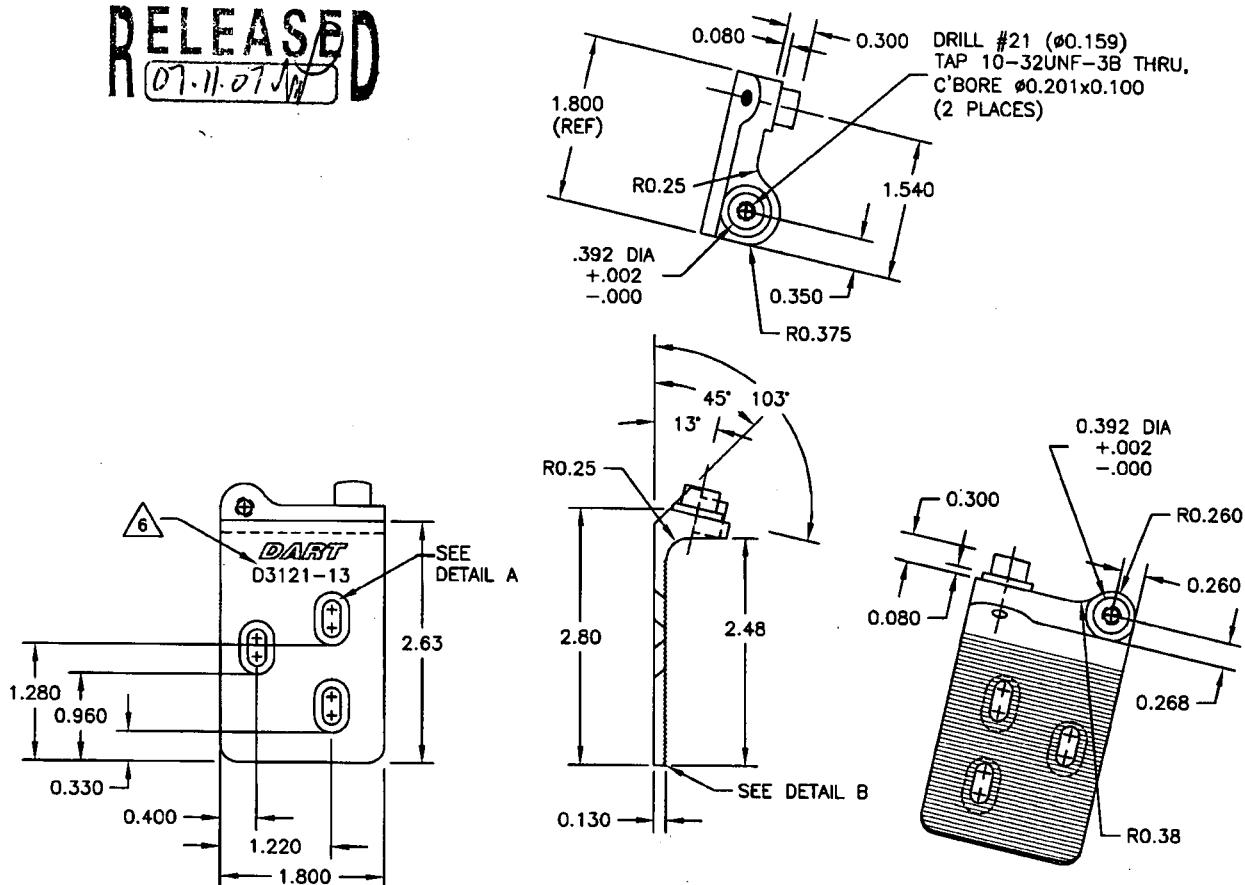
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		D3121	SHEET 5 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

**RELEASED**  
07.11.07 JMW**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

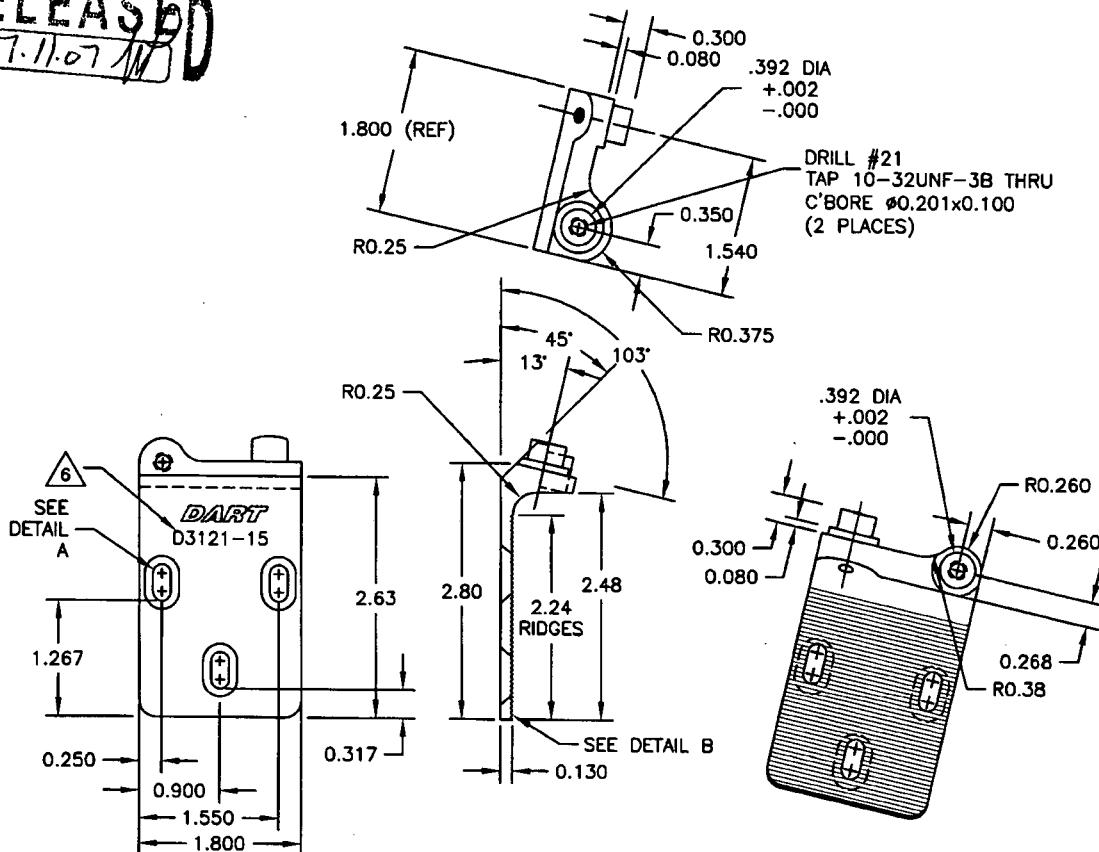
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DATE		REV. E SHEET 6 OF 10 TITLE SCALE 1:2

07.11.07

**RELEASED**  
07.11.07



**D3121-15 BRACKET (SHOWN)**  
**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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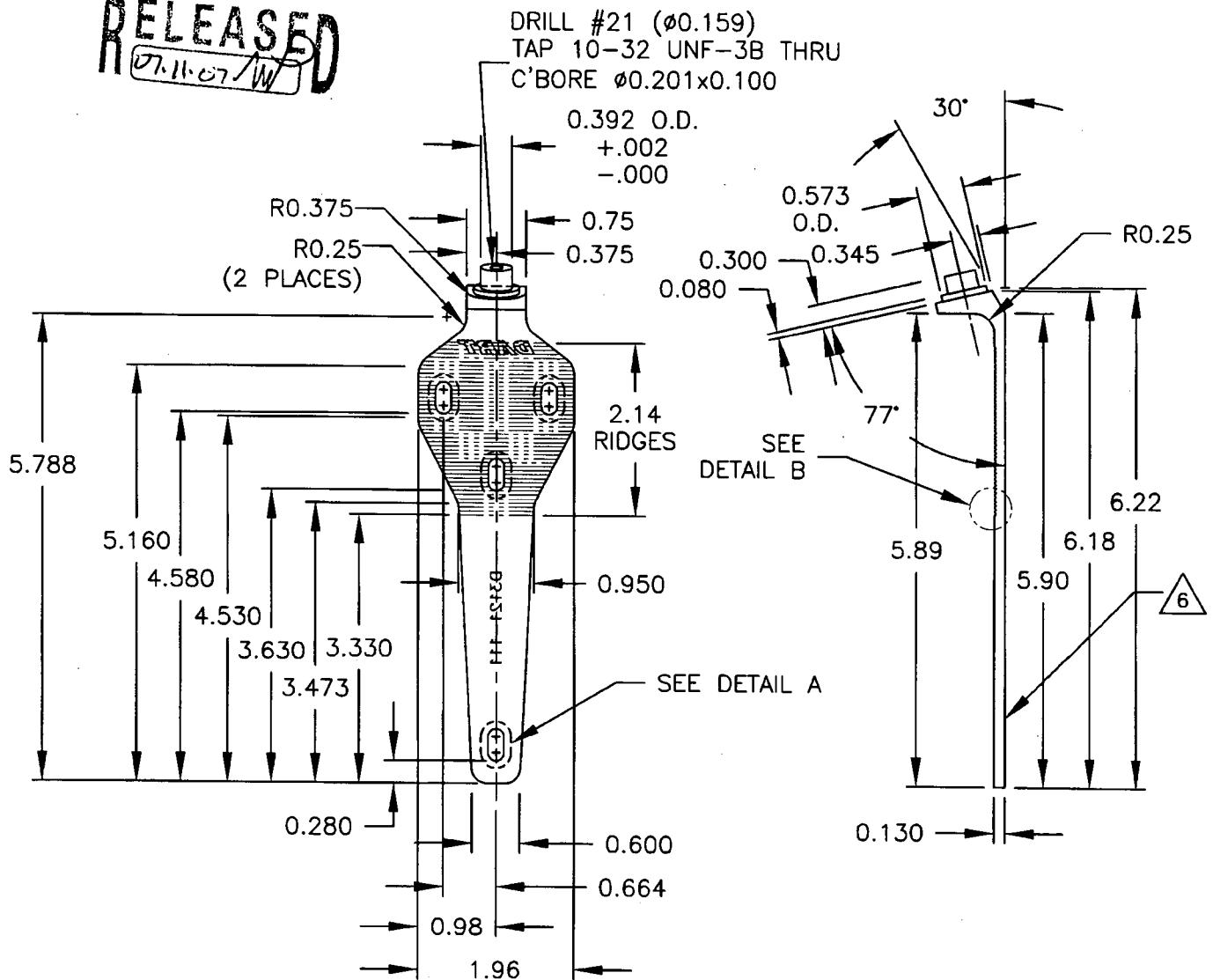
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
07.11.07 / W



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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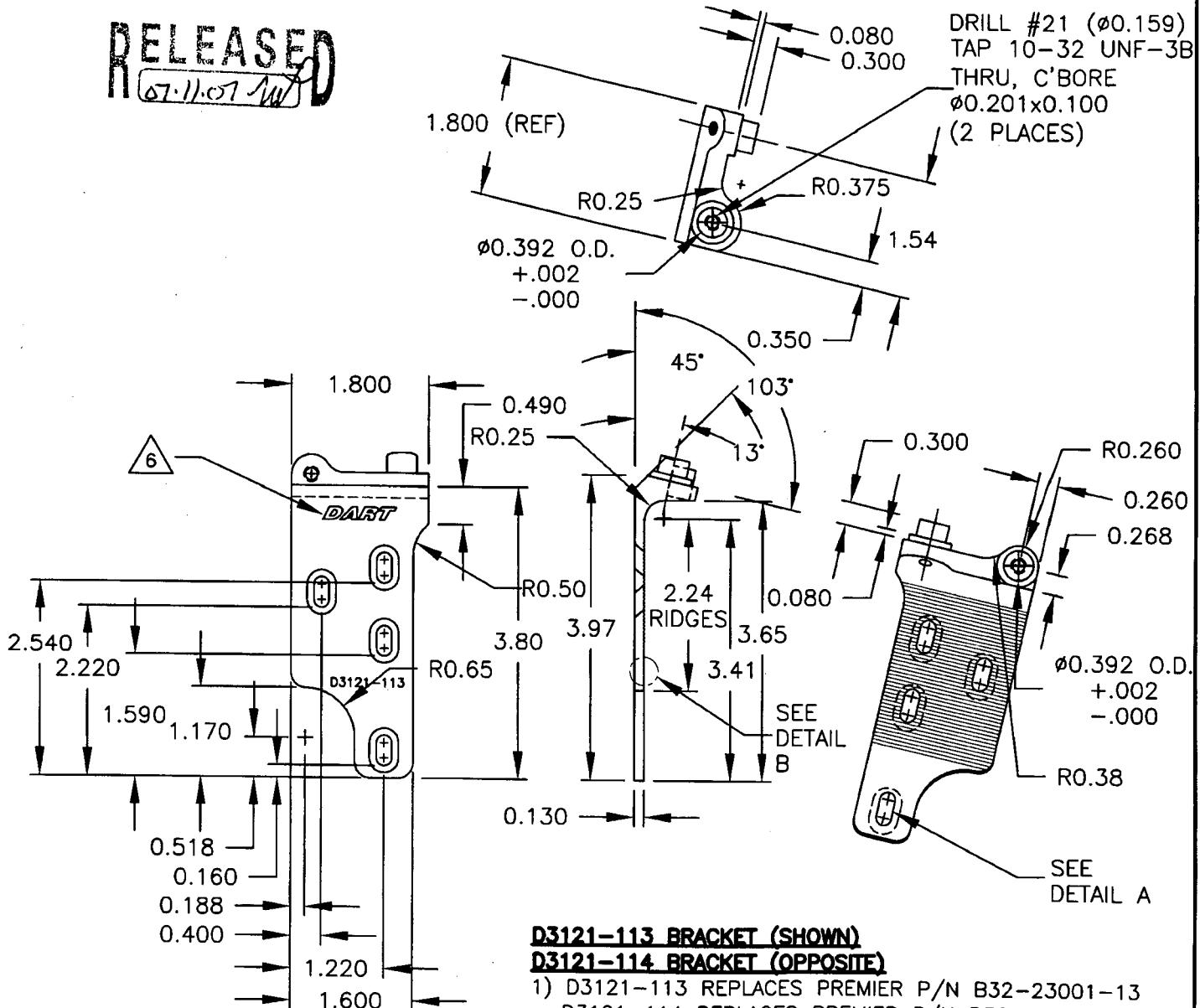
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CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 8 OF 10
DATE	TITLE	SCALE	1:2
07.11.07	BRACKET ASSEMBLY		

**RELEASED**  
07.11.07 M**D3121-113 BRACKET (SHOWN)  
D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi

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3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

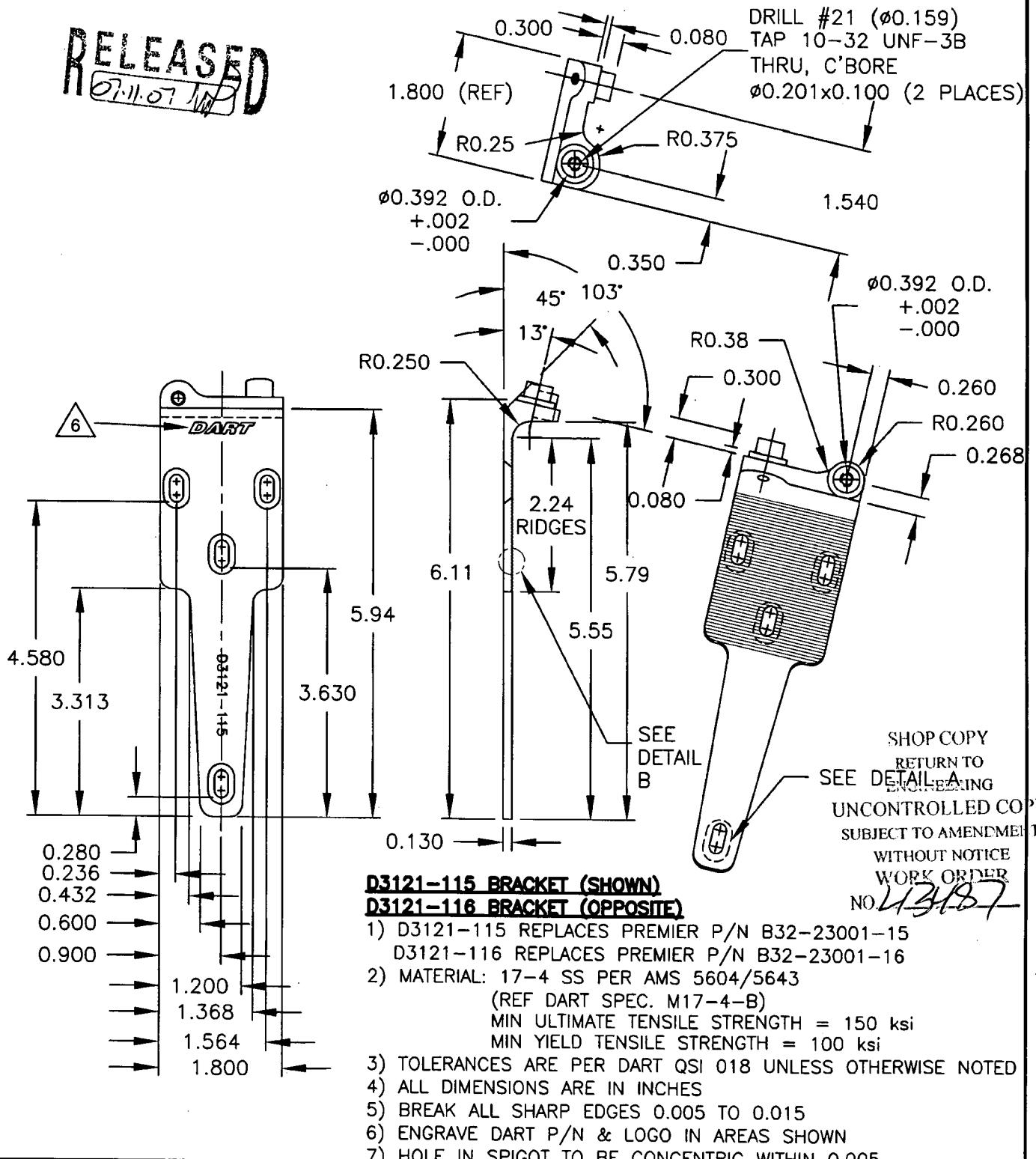
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.015  
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN  
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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		D3121	SHEET 9 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

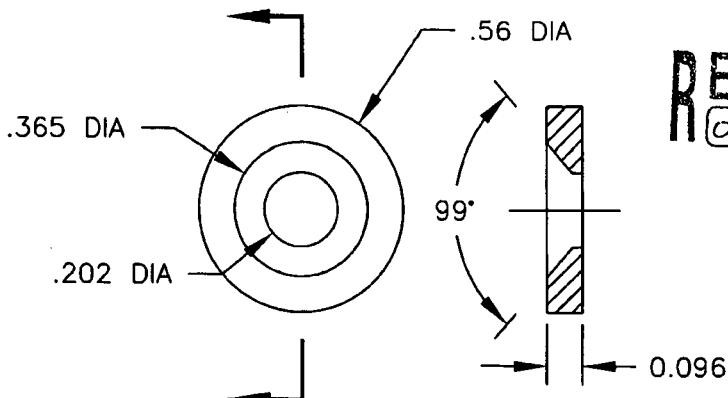
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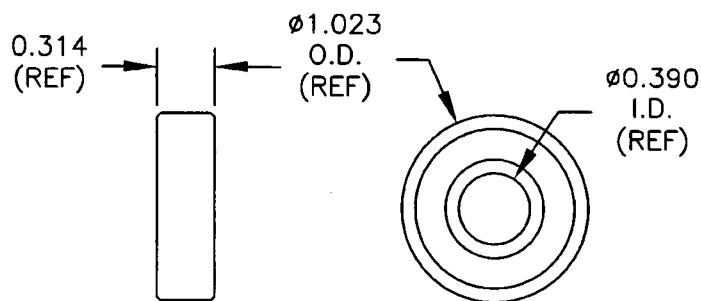
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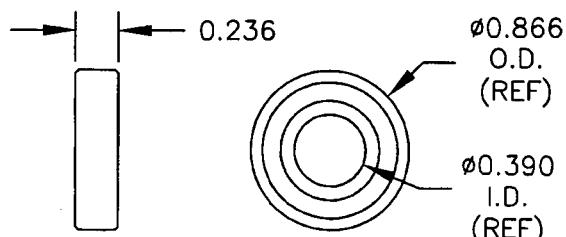
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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		D3121	SHEET 10 OF 10
DATE	TITLE	SCALE	1:1
07.11.07	BRACKET ASSEMBLY		

**D3121-17 WASHER (SCALE 2:1)**

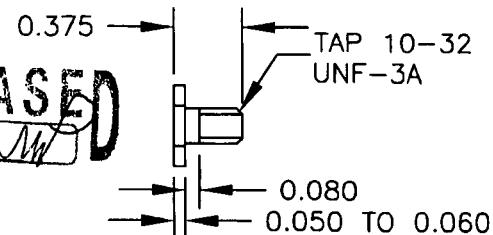
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

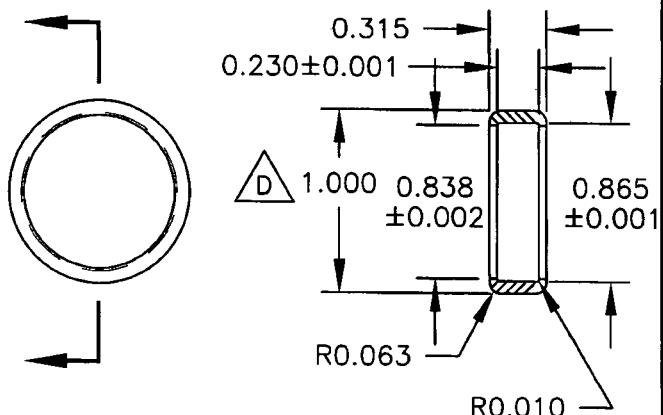
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

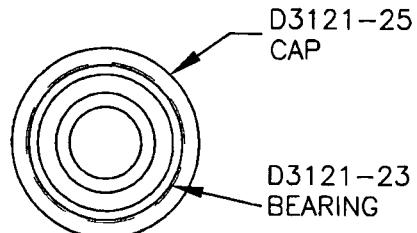
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**